

Date: Tuesday, 4/29/2008 10:19:55 AM
 User: David Duval

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT ASSY (RH)
 Job Number : 38873
 Estimate Number : 13286
 P.O. Number : Part Number : D3699042
 This Issue : 4/29/2008 S.O. No. : Drawing Number : D3699 PRELIM
 Prsht Rev. : NC Project Number : N/A
 First Issue : // Type : SMALL / MED FAB Drawing Revision : PRELIM
 Previous Run : Material :
 Written By : AD 08/04/30 Due Date : 5/6/2008 Qty: 1 Um: Each
 Checked & Approved By :
 Comment : Est Rev:A 08-04-25 new issue DD verified by:ec

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

Job Number:



PRELIMINARY ISSUE

Seq. #: Machine Or Operation: Description :

1.0 M6061T6S050 6061-T6 .050 Sheet



Comment: Qty.: 0.4797 sf(s)/Unit Total: 0.4797 sf(s)
 6061T6 aluminium sheet .050" thick
 (M6061T6S050)
 Batch: 104186 IB 8-4-30

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3699
 Dwg Rev: A IB 8-4-30
 Prog Rev: A
 ***grain direction along 9.00" ***
 2- Deburr if necessary IB 8-4-30

①

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/04/30 AD

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Bend as per Dwg D3697

IB 08-05-01 ①

B.1 counter sink holes as per dwg D3699 FF 08-05-01 ①

AD 08/04/30

B.2 QC5

08/05/01

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6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

08/05/07 / 08.05.06 ①

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-05-07

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

2:45pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

3:15pm

08-05-06

②

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/05/07

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

11.0

MS21059L3

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Nut Plate

batch: M106042

✓ ml 08/05/09

12.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rivet

batch: M1563

✓ ml 08/05/09

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3699

ml 08/05/09 x1

14.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

11/08.05.09 / 08/05/09 (10)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

give to David Duval

FOR KIT B/N 39207

08.05.13

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.05.13 Prototype

Job Completion



*Charge to
w/o # 00235*

U 08.05.23

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-776-011

Job #: 00235

Date: 25-Apr-08

Product Name: B412 Glareshield

Requested By: MP for RF

Design Manager Approval: 

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3697-1	Tube	31/03/2008	y	09-May-08		
1	D3797-1	Ground Plate	31/03/2008	y	09-May-08		
1	D3697-3	Support Plate LH	31/03/2008	y	09-May-08		
1	D3697-4	Support Plate RH	31/03/2008	y	09-May-08		
1	D3698-1	Support Angle	31/03/2008	y	09-May-08		
1	D3690-1	Glareshield	31/03/2008	y	09-May-08		
1	D3697-041	Tube assy	31/03/2008	y	09-May-08		
1	D3699-041	Support Assy	31/03/2008	y	09-May-08		
1	D3699-042	Support Assy	31/03/2008	y	09-May-08		
1	D3690-041	Glareshield Assy	31/03/2008	y	09-May-08		

